

NCR 19-7525

303 R2.00 ✓



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3912-1**Job Sheet 189157****Part No:** D3912-1**Job Qty:** 30 pcs**Part Name:** Eyebolt**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/21/19**Job Tracking No:****Due Date:** 2/20/19**Created By:** Dara Macdonald**Type:** Stock**Description:****Note:** DWG REV B IPP RevA: New issue DD verified by:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	30 pcs	2/20/19	2/20/19	0.00	21.43	Doosan - 1	
110	QC 2	30 pcs	2/20/19	2/20/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	

**Container No:** S151042**Part:** D3912-1**Job No:** 189157**Serial No/Batch:** S151042**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 02/05/19

Dart Aerospace Ltd.

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 QC 8	30 pcs	2/20/19	0.00	0.00	QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
130 Packaging 3-1 - Stock - B4B 30 pcs	30 pcs	2/20/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
140 QC 21 - SA	30 pcs	2/20/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	

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DAS
6
9-89
FEB 15 2019

DAS
21
9-89
FEB 15 2019

Part Op 100 - (Doosan Lathe) TURN AS PER FOLIO FA871AND DWG Prog Rev:_____ Debur as required
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location:_____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	8.4000 ft (.28 ea)	100-Doosan - 1	

Job Allocations

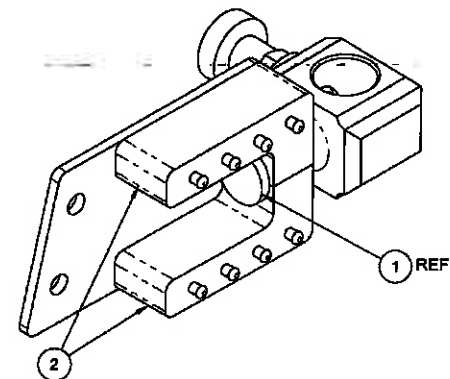
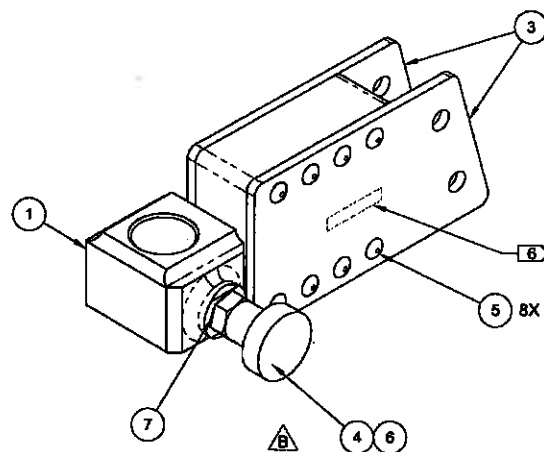
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	8	16	0

34 1/4
 34 1/2
 34 1/2
 34 1/2
 34 1/2

-2.457

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.1245	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	.699	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	.4995	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	.9035	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.135	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	45°	
7	Eyebolt	0.220Inches ± 0.030	0.250 0.190	.220	
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	.754	
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	.9715	
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.720	
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.1985	
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	.6235	
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.228	
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	R1/8	Radius
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	R.0065	Radius
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	.624	
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	.648	
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.098	
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	.439	
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	R1/8	Radius
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.003	
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	.245	
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	.878	
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	.109	
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	.727	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F815	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3910-1 SPRING PLUNGER; D4028-041 RMV: MS21209-F815 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0883R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5		
DRAWN	1/1		
CHECKED	1/1		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3912

REV. B

SHEET 1 OF 3

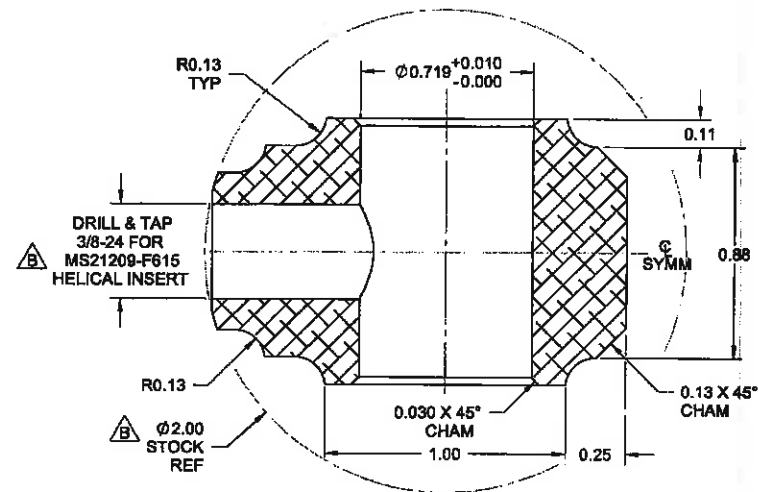
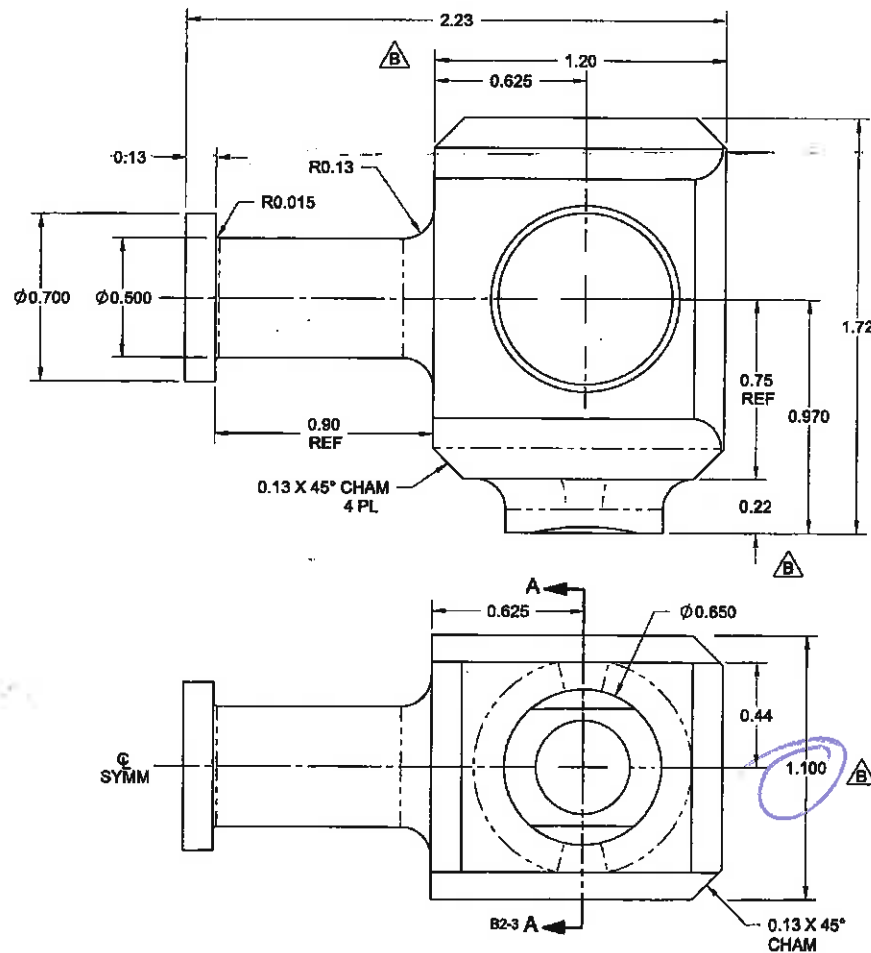
TITLE
EYEBOLT RECEIVER ASSY

SCALE

NTS

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SECTION A-A B6-3

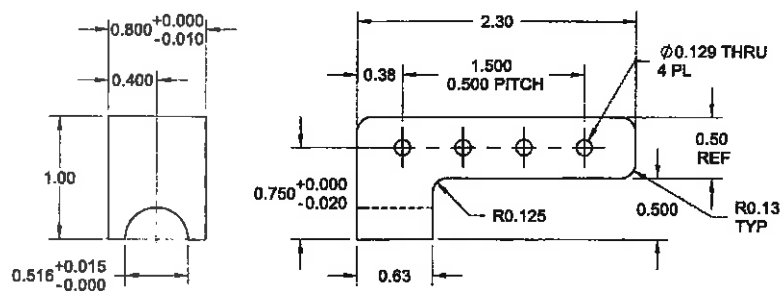
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D3912-1 EYEBOLT

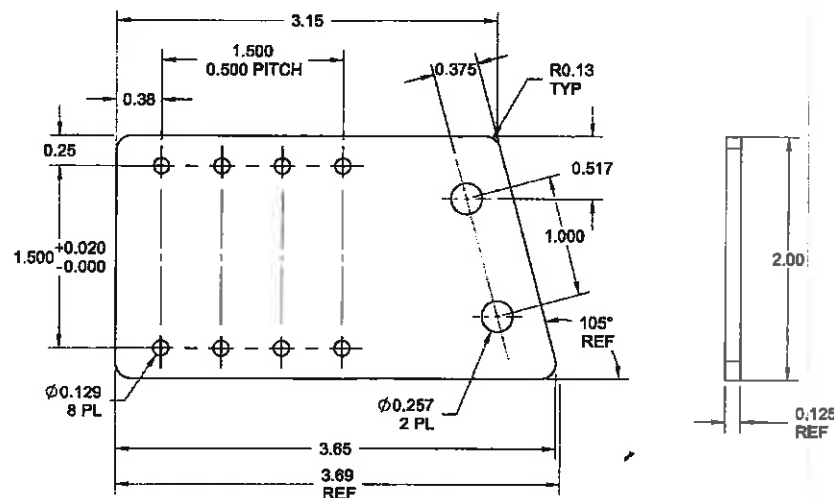
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO.	REV. B
MFG. APPR.	AKS	D3912	SHEET 3 OF 3
APPROVED	AKS	TITLE	SCALE
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Oct 24/19



Route update only

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J